

Date: Tuesday, 4/25/2006 8:36:47 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 26817		
Estimate Number	: 11172		
P.O. Number	: N/A	Part Number	: D22827
This Issue	: 4/25/2006	Drawing Number	: D2282 REV E
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 25135	Material	: N/A
Written By	<i>See J.G. COMMENTS Below</i>		
Checked & Approved By	<i>J.G. 06.04.25</i>		
Comment	Est'Rev:A	Removed from 9 Digit	05-12-02 JLM
Qty:	200	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0675W091	304 RD Tube .675 x .091W
		<i>Comment: Qty.: 0.0699 f(s)/Unit Total : 13.9860 f(s) Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) Batch M19524</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		<i>Comment: HARDINGE CNC LATHE SMALL</i>
		<i>1-Turn as per Dwg D2282 and Folio FA190</i>
		<i>2-Deburr (not done) SAD deburred 06.06.01 J.G. 06/06/01 200</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</i>
4.0	QC8	SECOND CHECK
		<i>Comment: SECOND CHECK</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WS21</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TUBE

Job Number: 26817

Part Number: D22827

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

200
DJ 06/26/07

Job Completion



U 06/26/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26817
Description: Handle Tube	Part Number:	D2282-7
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

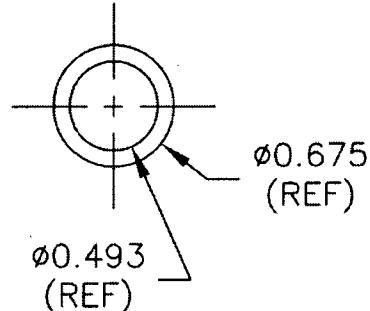
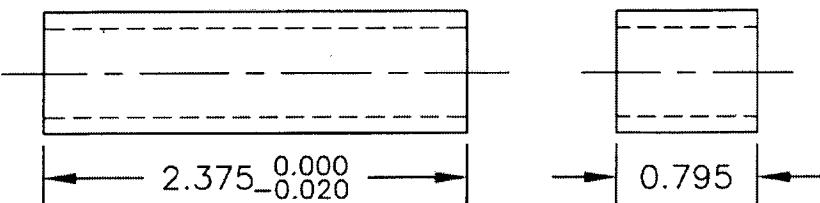
Measured by:	J.G	Audited by:	JL	Prototype Approval:	N/A
Date:	06/06/01	Date:	06/06/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	0.795 was 0.750	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	

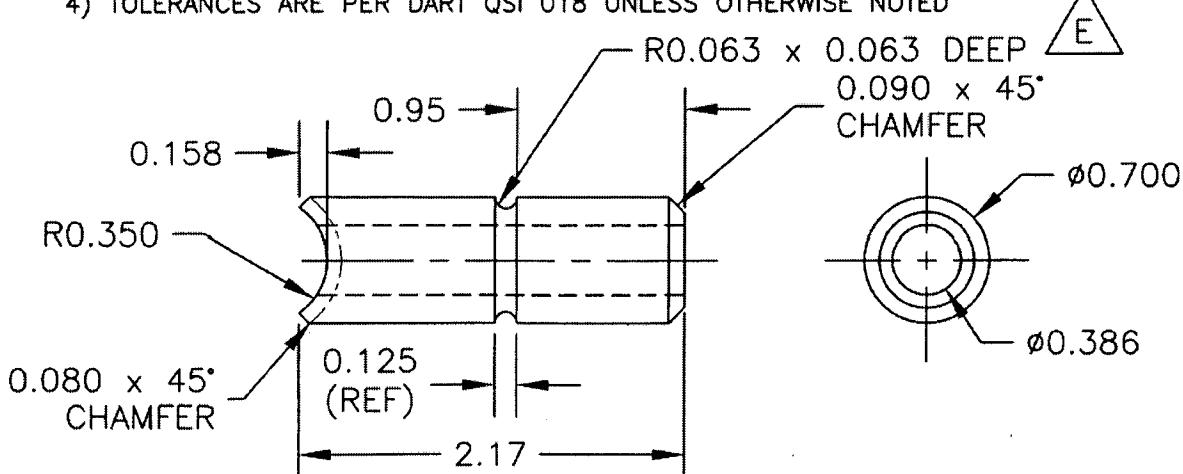
DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Initials]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
R [initials]
05/09/16

**D2282-3****D2282-7****D2282-3/7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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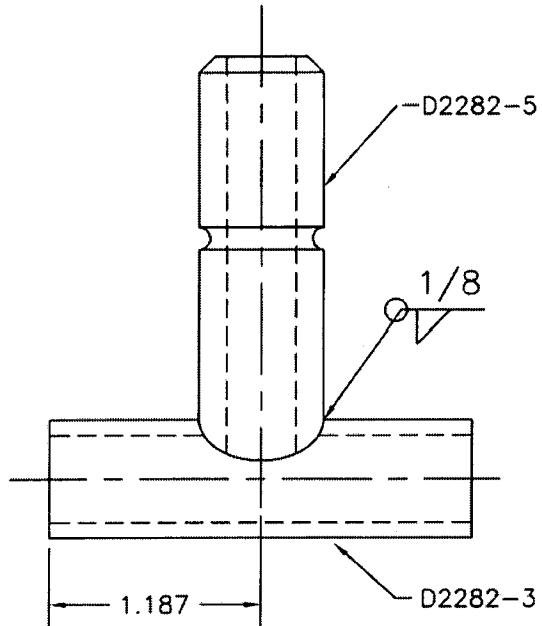
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WORK ORDER
NO. 26817

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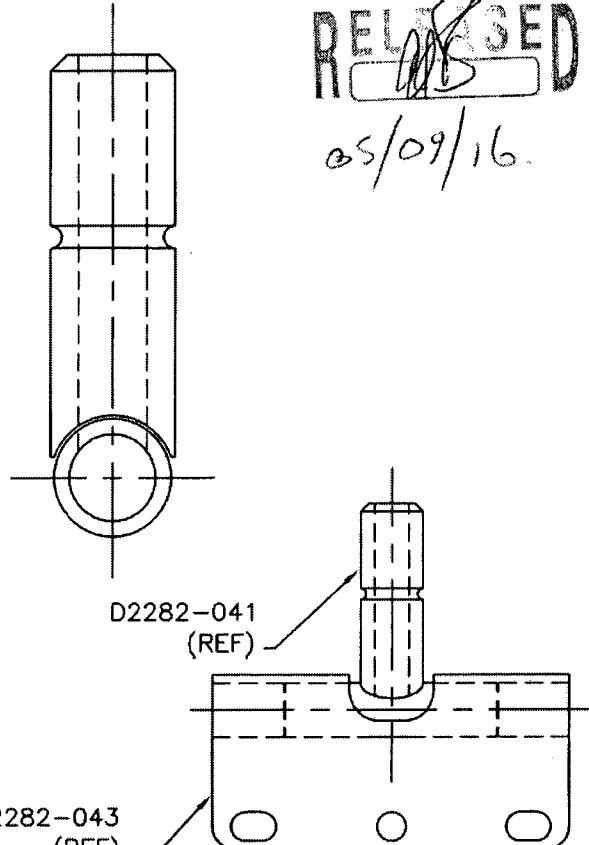
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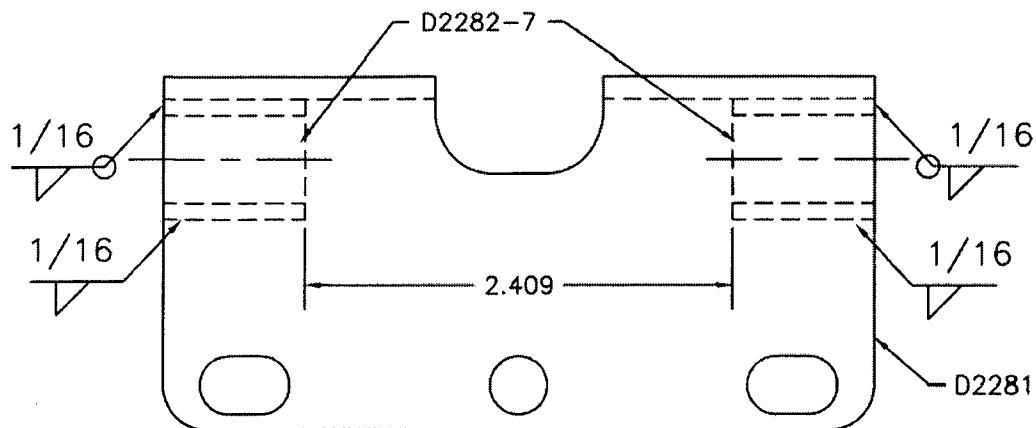
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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